

Sept 12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:16:46 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28156
Estimate Number : 11027
P.O. Number : N/A
This Issue : 15/08/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 25708
Written By :
Checked & Approved By :
Comment : Est:B 02.03.18 Re-format NG
Est:C 06.02.13 Removed p/c EC

Drawing Name : ARM
Part Number : D28021
Drawing Number : D2802 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 08/09/2006 Qty: 14 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
<p>Comment: Qty.: 1.5750 f(s)/Unit Total: 22.0500 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 bar 6.00" x 0.50" Batch: <u>Mei 417</u></p>		
2.0	BAND SAW	BAND SAW
<p>Comment: BAND SAW Cut blanks 15.800" long</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		
5.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p>		



J.G 06/08/16 14



J.G 06/08/16 14



J.L 06/08/20 14



J.L 06/08/20 14



J.L 06/08/22 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:16:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 28156

Part Number: D28021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr NO sharp edges.

SA 06.08.23

14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 06.08.23

14

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA28

SA 06.08.23

14

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SA 06.08.23

Job Completion



SA 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

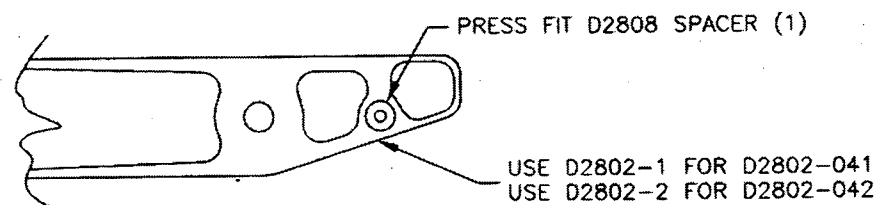
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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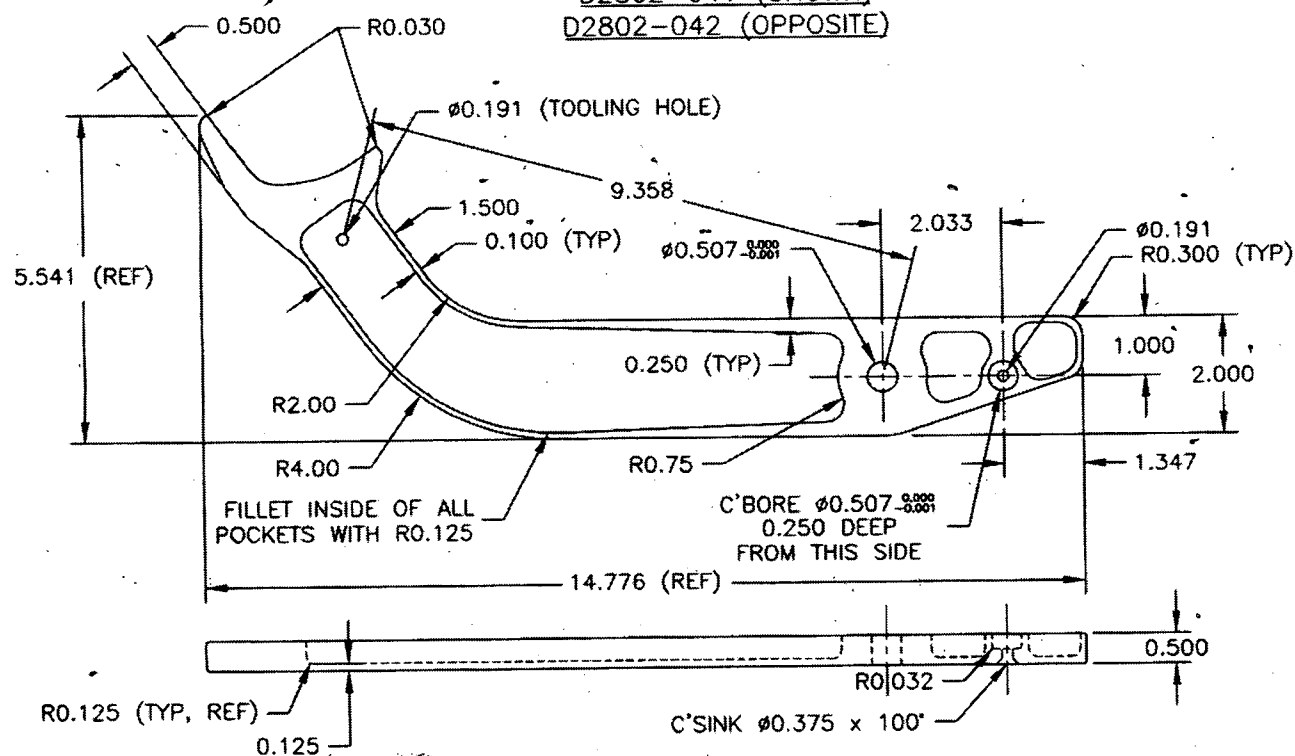
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	DRAWING NO. D2802
A	00.11.03	NEW ISSUE
		REV. A
		SHEET 1 OF 1
		SCALE 1:3



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00-11-13

DART AEROSPACE LTD		Work Order: 28156
Description: arm		Part Number: D2802-1
Inspection Dwg: D2802 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.504	✓			
Ø.191	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.193	✓			
1.500	$\pm .010$	1.502	✓			
.100	"	.100	✓			
9.358	"	9.358	✓			
Ø.507	$\begin{matrix} +0 \\ -.001 \end{matrix}$.507	✓			
2.033	$\pm .010$	2.033	✓			
1.000	"	1.000	✓			
2.000	"	2.002	✓			
1.347	"	1.347	✓			
r.75	$\pm .030$.75	✓			
r.030	$\pm .010$.030	✓			
r.125	"	.125	✓			
.500	"	.502	✓			
.125	"	.135	✓			
Ø.507X.250	"	.07X.243	✓			
Ø375X100°	$\pm .010 \pm \frac{1}{2}^\circ$.375X100°	✓			

Measured by: J.L. / [Signature]	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 06/08/19	Date: 06/08/19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]